Date:

Monday, 1/8/2007 10:53:08 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 30158B

P.O. Number

: 10294

This Issue

: NA

: 1/8/2007

Wha

: NC

S.O. No. : N/12

Type

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D3220041 : D3220 REV A1

: DOUBLER ASSEMBLY

Project Number

: N/A

Drawing Revision Material

Due Date

: 1/30/2007

Qty:

6 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est Rev:A

EC

Est: B 06.11.15 waterjet

Additional Product

Job Number:



Seq. #:

Description:

1.0

M2024T3S050

2024-T3 .050 sheet



Comment: Qty.:

0.7266 sf(s)/Unit Total:

4.3596 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050 Identify for D3220-1

Batch:



2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut D3220-1 as per Dwg D3220

Dwg Rev: A1 Prog Rev: A2



2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

4.0

Comment: SECOND CHECK





5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
•			·								

Part No:	PAR #:	Fault Category:	NCR: Yes N	o DQA :	Date:
			QA: N/C	Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annessal	A	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
				.*				1	
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			···						
		*							
						j]	

NOTE: Date & initial all entries

Monday, 1/8/2007 10:53:08 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: DOUBLER ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3220041 Job Number: 30158B Job Number: Description: Seq. #: Machine Or Operation: 2-C'sink D3220-1 as per Dwg D3220 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 MS20426AD34 8.0000 Each(s)/Unit 48.0000 Each(s) Comment: Qty.: Total: Pick: **Qty Part Number** Description Batch M102404 8 MS20426AD3-4 Rivet MS21059L4 Nutplate 10.0 4.0000 Each(s)/Unit Total: 24.0000 Each(s) Comment: Qty.: Description Batch_ **Qty Part Number** 4 MS21059L4 SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 11.0 Xb Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3220-041 doubler as per Dwg D3220 INSPECT WORK TO CURRENT STEP 12.0 QC5 67.02.006 WORK TO CURRENT STEP Comment: INSPECT

Form: rprocess

Page 2

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W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			_								
Part No	·	PAR #: Fault Category: N	CR: Yes	NO DQA	1:20	_ Date: <u><</u>	7/02/12				
			QA:	N/C Closed	l:	_ Date:					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		ViCdi	Approval Chief Eng	Approval QC inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		
						,		
<i>)</i>								
						3		

NOTE: Date & initial all entries

Date:

Monday, 1/8/2007 10:53:09 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 30158B

Part Number: D3220041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

14.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54-93

QC21



Job Completion



Comment: FINAL INSPECTION/W/O RELEASE

Dart Aerospace Ltd

N/O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #: _	Fault Category:	NCR: Yes No	DQA:	Date:	
			QA: N/C (Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	Ammunual		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30158B
Description: Doubler	Part Number:	D3220-1
Inspection Dwg: D3220 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.51	~	- 1	Very measuring	
14.25	+/-0.030	14.25	/		Measuring tane	
R0.50	+/-0.030	20.50	~		R-G	
7.00	+/-0.030	7.00	1		Veru	
7.000	+/-0.005	7.005			Vern	
1.50	+/-0.030	1,505	./		Vern	
1.000	+/-0.005	1,001	/		Vern	
0.500	+/-0.005	0,502			Vern	
1.000	+/-0.005	1.000	1		Vern	
0.316	+0.005/-0.000	0.316			Verm	
0.098	+0.005/-0.000	0.098	/		Vern	
0.050 thick	+/-0.005	0,049	/		Vern	
Grain Direction	N/A	८ >	Î			
			- #1 #1-72			

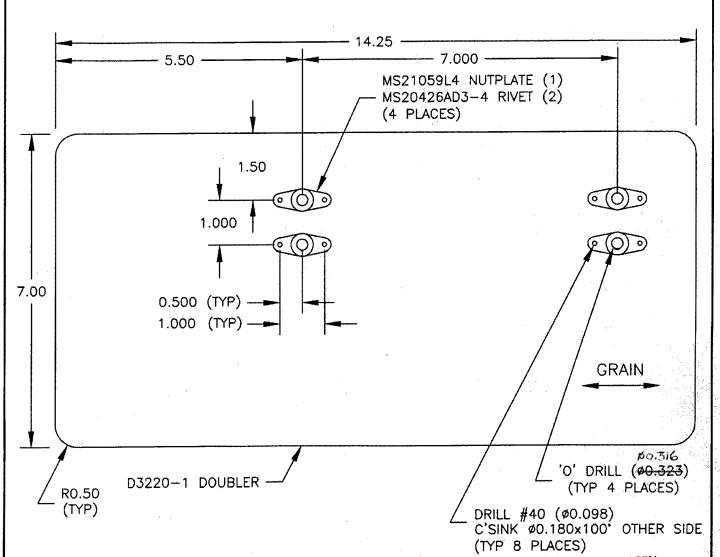
Measured by:	SAD	Audited by:	W	Prototype Approval:	N/A
Date:	07:01:20	Date:	07/01/22	Date:	N/A

Rev	Date	Change		Revised by	Approv∉d
Α	04.02.27	New Issue	P/O D412-698-013	KJ/RF	
					//



	DESIG	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHEC	(ED #	APPROVED	DRAWING NO. D3220	REV. A SHEET 1 OF 2
	DATE 03.10.16			TITLE	SCALE
				DOUBLER	1:2
	Α		03.10.16	NEW ISSUE	·
	ΔΙ	WH	03.11.13	CORRECTED DIES	

PELEASED



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER) OP COPY

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.090)

ENGINEERING

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

SUBJECT TO AMENDMENT

4) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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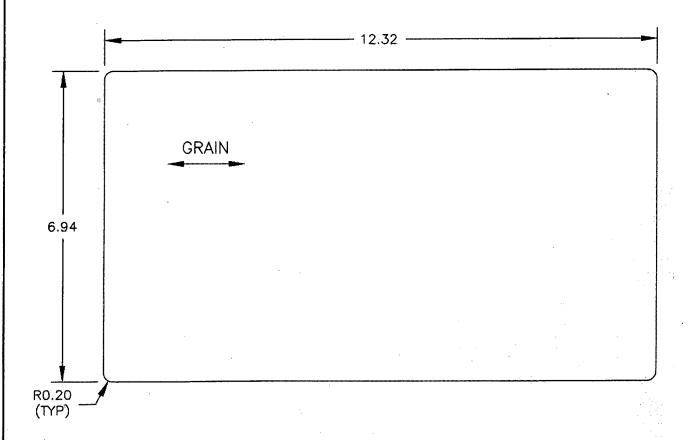
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DESIGN #	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECKED	APPROVED,	DRAWING NO.	REV. A
1 91	-	D3220	SHEET 2 OF 2
DATE		TITLE	SCALE
03.10.16		DOUBLER	1:2





D3220-3 DOUBLER

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.050)

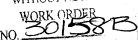
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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